

Work Order ID 139362

November 25, 2015 3:20:44 PM

139362

Page 1

Item ID: D205-633-011

Revision ID:

Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015 Start Qty: 4.00

Required Date: 12/11/2015 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: SH

Date: 20151125

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D205-633

C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP205-633-011 CHG001

DAS
27
9-89

MCS DEC 01 2015

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

NOV 30 2015
DAS
28
9-89

120

QC 100% inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

3X

DAS
27
9-89

B138863 (X2)

B137610 (X1)

DEC 01 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Item ID: D205-633-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Stop

NS2

Start Date: 11/25/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/11/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location:FG082								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

SMB
12/12/18 3x

MLJ DEC 01 2015

Jd 11/25/2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					

Root Cause <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Environment ☐</td> <td style="width: 15%;">No Re-verification ☐</td> <td style="width: 15%;">Pressure/Forced ☐</td> <td style="width: 15%;">Temperature/Cure ☐</td> <td style="width: 15%;">Power Loss/Surge ☐</td> <td style="width: 15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="text-align: center; vertical-align: top;"> OTHER : _____ </td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				Misidentified ☐	Past Due ☐
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Picklist Print

November 25, 2015 3:20:52 PM

Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:F02.07.11Reformat; Removed D3010 RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased	No			110	Each	243.0000	1	4			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

AN4-14A

Bolt

DAS
6
9-89
DAS
28
9-89

Location	Loc Qty	Loc Code
FG	5	
122141	5	
ST325A	150	
M133316	150	
ST344	88	
M129384	8	
M133284	80	

DAS
27
9-89
XY

AN4-5A		Purchased	No			110	Each	136.0000	2	8			
--------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

AN4-5A

BOLT

DAS
28
9-89

Location	Loc Qty	Loc Code
CA	55	
m129682	55	
ST325A	50	
m133064	50	
ST345	31	
120562	4	
6651	1	
m132317 //	26	

DAS
27
9-89
XY

DAS
6
9-89
NOV 30 2015

2
5

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Work Order ID: 139362

139362

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No 110 Each 526.0000 2 8

AN4-6A

BOLT

DAS
27
9-89 X4

Location

Loc Qty

Loc Code

CA	143	
M128403	43	
M130851	100	
ST325A	100	
M133363	100	
ST345	283	
M128403	8	
M133316	275	

DAS
6
9-89
DAS
28
9-89

AN4-7A Purchased No 110 Each 65.0000 2 8

AN4-7A

Bolt

DAS
27
9-89 X4

Location

Loc Qty

Loc Code

ST325	65	
m126193	2	
m131320	63	

DAS
6
9-89
DAS
28
9-89

AN5-14A Purchased No 110 Each 28.0000 1 4

AN5-14A

Bolt

DAS
27
9-89 X4

Location

Loc Qty

Loc Code

ST299A	25	
m132763	25	
ST338	3	
m132823	3	

DAS
6
9-89
DAS
28
9-89
NOV 30 2015

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Work Order ID: 139362

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Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

AN5-6A

Purchased

No

110

Each

14.0000

1

4

AN5-6A

Bolt

**

DAS 28
6 9-89
NOV 30 2015

Location

Loc Qty

Loc Code

ST286A

10

m133515

10

ST339

4

m131957

4

D2021-101

Manufactured

No

110

Each

22.0000

1

4

D2021-101

Eyebolt

**

DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST001

22

130984

22

D2022-10127

Manufactured

No

110

Each

129.0000

2

8

D2022-101

Spacer

**

DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST001

39

107903

39

ST012a

90

132703

90

D2022-103-03

Manufactured

No

110

Each

35.0000

2

8

D2022-103

Spacer

**

DAS 28
6 9-89
NOV 30 2015

Location

Loc Qty

Loc Code

ST001

19

123938

19

ST012a

16

134288

16

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Work Order ID: 139362

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Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

D2562-001	Manufactured	No	110	Each	9.0000	1	4	
D2562-001								
Strut 19.68"								

DAS
27
9-89 X4

Location	Loc Qty	Loc Code
ST353	9	
134240	1	
138063	8	

DAS
28
9-89

D2563	Manufactured	No	110	Each	0.0000	1	4	
D2563								
Step Weldment Assembly								

DAS
27
9-89 X3

B**138863 X2
B13760 X1

DAS
6
9-89

D2565-101	Manufactured	No	110	Each	11.0000	1	4	
D2565-101								
Strut								

DAS
27
9-89 X4

Location	Loc Qty	Loc Code
ST353	11	
129688	3	
131707	1	
134294	1	
137611	3	
138868	3	
134240	3	

DAS
6
9-89

D2565-103	Manufactured	No	110	Each	11.0000	1	4	
D2565-103								
Strut								

DAS
27
9-89 X4

Location	Loc Qty	Loc Code
ST353	11	
121437	1	
131730	2	
134308	2	
137624	3	
138885	3	

DAS
28
9-89

NOV 30 2015

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D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

D2565-105	Manufactured	No	110	Each	11.0000	1	4
-----------	--------------	----	-----	------	---------	---	---

D2565-105

Strut

DAS
27
9-09

Location

Loc Qty

Loc Code

ST353

11

117052

3

134444

2

137711

3

138987

3

**

DAS
28
9-09

D2565-107	Manufactured	No	110	Each	8.0000	1	4
-----------	--------------	----	-----	------	--------	---	---

D2565-107

Strut

DAS
27
9-09

Location

Loc Qty

Loc Code

ST354

8

130046

1

131128

1

136248

3

137782

3

**

DAS
28
9-09

D2565-109	Manufactured	No	110	Each	11.0000	1	4
-----------	--------------	----	-----	------	---------	---	---

D2565-109

Strut

18

DAS
27
9-09

Location

Loc Qty

Loc Code

ST354

11

131882

3

136192

2

137713

3

138988

3

**

NOV 30 2015

DAS
28
9-09

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Start Date: 11/25/2015

Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

D2565-111

Manufactured No

110

Each

12.0000

1

4

D2565-111

Strut

Location

Loc Qty

Loc Code

ST354

12

131027

1

134455

5

137719

3

138996

3

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

MS21042L4

Purchased

No

110

Each

1,482.000

8

32

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

57

m127813

57

ST260a

138

m130799

56

m131803

6

m132262

76

ST303

1116

m133363

1116

ST305

169

m128300

8

m130388

7

m130922

97

m132123

56

m133316

1

DAS
28
9-89
NOV 30 2015

DAS
27
9-89

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Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

110

Each

603.0000

2

8

MS21042L5

Nut

Location

Loc Qty

Loc Code

CCK004

200

m133577

200

GA

146

m127813

146

ST303

9

m132677

9

ST304

200

m133363

200

ST305

48

m127813

19

m131340

21

m132123

8

DAS
27
9-89

xy

9-6
9-89
NOV 30 2015
DAS
28
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Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

110

Each

3,992.000

15

60

NAS1149D0463.J

WASHER

BAS
27
9-89
XY

Location

Loc Qty

Loc Code

GA

432

M129390

41

M132035

391

ST260a

1500

M133316

1500

ST263

618

M133284

618

ST269

1442

M129682

47

M130799

371

M132317

101

M132677

888

M133077

35

DAS
6
9-89
NOV 30 2015

DAS
28
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Required Date: 12/11/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

1,127.000

4

16

NAS1149D0563.J

Washer

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

128

m130799

63

m132035

55

m132256

10

ST263

747

m133134

247

m133363

500

ST269

180

m128257

156

m132677

24

ST271

19

m131026

19

X4 DAS
27
9-89

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5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: C

Date: 13.12.13